

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027127**Date Inspected:** 31-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA

<b>CWI Name:</b>	Chris Concha		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No

**Bridge No:** 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

**SAS WB Maintenance Traveler**

This QA Inspector randomly observed WMI production welder Mr. Daniel Grayum (WID # 3049) performing Flux Core Arc Welding (FCAW) activities on the SAS WB Traveler piping, sump pump & swing arm brackets. This QA Inspector observed Mr. Grayum welding in all positions on brackets to tube steel material, randomly throughout the shift.

**E2/E3 Parking Tether Anchor Clamp**

This QA Inspector randomly observed WMI production welder Mr. Cesar Canales (WID #3195) performing Flux Core Arc Welding (FCAW) activities on the E2/E3 Parking Tether Anchor Clamp. This QA Inspector observed Mr. Canales tack welding in the 2F position on Parking Tether Anchor Clamp Assemblies, randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Chris Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS

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## WELDING INSPECTION REPORT

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and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

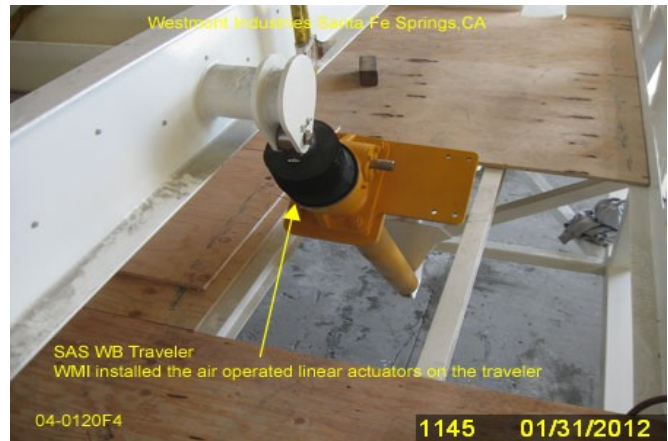
### SAS Travelers Supplementary Access Platforms

This QA Inspector made random shop observations and was informed by (WMI) production fitter Mr. Larry Swanson (WID #3058) that welding on the SAS Travelers Supplementary Access Platforms is still on hold pending RFI request to change the fit at hinge location.

### SAS WB Traveler

This QA Inspector randomly observed WMI personnel installing air operated linear actuators on the SAS WB Traveler.

This QA noted above items observed appear to comply with contract documents.



### Summary of Conversations:

As stated within this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Brannon, Sherri

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer

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